Work Order ID 5883
--------------------

Wednesday, May 19, 2010 1:09:25 PM



Page 1

Item ID:

D3657-1

Accept

Setup Start

Stop



**Revision ID:** 

**Start Date:** 

Item Name:

**Required Date: 5/26/2010** 

Guide Tool

5/19/2010

Start Qty: 5.00 Req'd Qty: 5.00

**Cust Item ID:** 

**Customer:** 

Reference:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

**SPC (Y/N):** 

Date:

Stop



Sequence ID/ **Work Center ID** 

**Operation Description**  Set Up/ **Run Hours** 

Draw Number Draw Rev.

Plan Code

Accept Oty Qty

Reject Reject Number

Insp. Stamp

**Draw Nbr** 

**Revision Nbr** 

D3657 Rev A

100

Bandsaw

Jeaspa Bandsaw

**BAND SAW** 

Memo

0.00

0.00

and 10/08/27

110



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Cut blank 2.300

1- Mill as per Folio FA669Rev: △△ & Dwg D3657 Rev: △ □2-Deburr

" long

per dwg D3443

QC2- Inspect parts off machine FAI/FAIB

120

Memo

0.00 \$\$10/05/3)

Quality Control

Dart Aerospace Li
-------------------

W/O:			V	VORK ORDER CHANG	ES		· · · · · · · · · · · · · · · · · · ·			
DATE	STEP	PRO	PROCEDURE CHANGE By					Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Ca	tegory:	_ NC	R: Yes N	lo DQA:		Date:	
					QA: N/C Closed: Date:					
NCR:		V	VORK OR	DER NON-CONFORM	ANCE	(NCR)				
DATE STEP		Description of NC	Corrective Action Section E				Verification		Approval	Approval
DAIL	JILF	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section		Chief Eng	QC Inspector
		· <b>5</b> .								
		·								
										·

<sup>•</sup> NOTE: Date & initial all entries

### Work Order ID 58838

Wednesday, May 19, 2010 1:09:25 PM



Page 2

Item ID:

D3657-1

Accept

Setup Start



**Revision ID:** 

Item Name: Guide Tool

Required Date: 5/26/2010

5/19/2010

Start Qty: 5.00 Req'd Qty: 5.00

**Cust Item ID: Customer:** 

Reference:

**Start Date:** 

A	pprovals:	
<i>(</i> *)	ppi uvais.	

Process Plan:

Date:

Tooling:

Date:

Start Run



Date:

SPC (Y/N):

Date:

Stop

Stop

Sequence ID/ Work Center ID

130



Operation Description

QC8- Inspect parts - second check

Memo

Memo

Set Up/ **Run Hours**  Draw Number Draw Rev.

Plan Code Qty

Accept Reject **Qty** 

Reject Insp. Number Stamp

Quality Control

0.00

140



Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

5 Bl 106-1

150



**Quality Control** 

QC3- Inspect Part Finish

0.00

M 10/06/01

Memo

<b>Dart Aerospace</b>
-----------------------

W/O:			WC	ORK ORDER CHANG	ES						
DATE	STEP	PRO	CEDURE CHA	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
			,								
								:			
								***			
			i								
Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date:			
						QA: N/C Closed: Date:					
NCR:			WORK ORDI	ER NON-CONFORMA	ANCE (NCF	l)					
DATE	STED	Description of NC		Corrective Action Section		Verific	ication Approva	Approval	Approval		
DAIL	STEP Description of NC Section A		Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	& Section C		Chief Eng	QC Inspector		
					710010		····				
	,		, manual control of the control of t								

<sup>•</sup> NOTE: Date & initial all entries

#### Work Order ID 58838

Wednesday, May 19, 2010 1:09:25 PM



Page 3

Item ID:

D3657-1

Accept

Setup Start

Stop



**Revision ID:** 

**Start Date:** 

Guide Tool **Item Name:** 

5/19/2010

Start Qty: 5.00

**Required Date: 5/26/2010** 

Req'd Qty: 5.00



**Cust Item ID: Customer:** 

Reference:

A	nn	ro	val	s:

Process Plan:

Date:

**Tooling:** 

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ **Work Center ID** 

160

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location:

Set Up/ **Run Hours** 

0.00

0.00

Draw Number

Draw Plan Rev. Code

Accept Qty

Reject Qty

Reject Insp. Number

Stamp

170

QC21- Final Inspection - Work Order Release

0.00



QC Quality Control

Memo

Memo

0.00

10/06/02 A

Dart Aerospace Lt
-------------------

W/O:			, W	ORK ORDER CHAN	GES				
DATE	STEP	PRO	Ву	C	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
								:	
Part No	:	PAR #:	Fault Cat	egory:	NCR: Ye	s No	DQA:	Date: _	
Resolution:			Dispositi	on:	QA: N/C Closed: Da				
NCR:			WORK ORI	DER NON-CONFORM	IANCE (NO	CR)			, , , , , , , , , , , , , , , , , , ,
DATE	CTED	Description of NC		ction B		Verification	Approval	Approval	
DATE	STEP Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sigi Da		Section C	Chief Eng	QC Inspector	
			{						
			<u> </u>						
					1	ļ			ŀ

NOTE: Date & initial all entries

## **Picklist Print**

Wednesday, May 19, 2010 1:09:28 PM

Work Order ID: 58838

Parent Item:

D3657-1

Parent Item Name:

Guide Tool

Comments:

IPP Rev:A New Issue 07-01-15 JLM



**Start Date: 5/19/2010** 

Required Date: 5/26/2010

Page 1

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M6061T6B0.500X01.00		Purchased	No			100	f	22.6000	0.1916			

N BRING BINTO NATIONA DIA BINTO BANKA BANKA DIA BANKA BANKA BANKA BANKA DIA BANKA BANKA BANKA BANKA BANKA BANK

6061-T6 Bar .500 x 1.00

Loc Oty Location Loc Code

MAT01 22.6 107436 22.6

1.009 cml 10/05/27

# **Dart Aerospace Ltd**

W/O:			· W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	Ву	C	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
			ļ.					:	
<del></del>		· · · · · · · · · · · · · · · · · · ·	*						
			1						
			i						
Part No	•	PAR #:	Fault Cat	tegory:	NCR: Ye	es No	DQA:	Date:	1,
Resolution:									
NCR:		V	VORK ORI	DER NON-CONFORMA	ANCE (N	CR)			* ******
DATE	STEP	Description of NC		ion B		Verification	Approval	Approval	
DAIL	JILI	Section A	Initial Chief Eng	Action Description Chief Eng		n & ate	Section C	Chief Eng	QC Inspector
			1						
			:						
			1						

<sup>•</sup> NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	57838
Description: Guide Tool	Part Number:	D3657-1
Inspection Dwg: D3657 Rev: A		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype
---	---------------	-----------

	<del></del>	<del>-</del>	,		<u> </u>		· · · · · · · · · · · · · · · · · · ·
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comi	nents
Ø0.620	+0.008/-0.001	.622	/				,
0.50	+/-0.030	.503	1				
0.315	+/-0.010	.3/3	/				
2.00	+/-0.030	2.003		,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,			
1.50	+/-0.030	1.504	/			· · · · · · · · · · · · · · · · · · ·	
0.50	+/-0.030	.498	1				·
0.36	+/-0.030	.357	/				
R0.13	+/-0.030	125					
15°	+/-0.5°	15°					
				<del> </del>		<u>.</u>	<del></del>
							· · · · · · · · · · · · · · · · · · ·
						<u></u>	
						<del></del>	<u> </u>
				<u> </u>			
							<u> </u>
							<u>.</u>
· · · · · · · · · · · · · · · · · · ·			-				
				;			· · ·
						<u> </u>	
Measured by:		Audited by:	<u> </u>	5	Prototype Appro	oval:	N/A
Date: 19	25/31	Date:	10/05/31	,		ate:	N/A

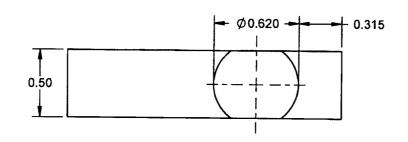
Measured by:	Audited by:	Prototype Approval:	N/A
Date: 19/05/31	Date: 10/05/3/	Date:	N/A

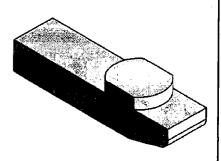
Rev	Date	Change	Revised b	y . A P	Approved
A	09.06.22	New Issue	KJ	*II	2
				7/	

## **Dart Aerospace Ltd**

	•		the state of the s							•		
W/O:			W	ORK ORDER CHA	ANGES					· · · · · · · · · · · · · · · · · · ·		
DATE	STEP	PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
			1									
							İ					
Part No	:	PAR #:	Fault Cat	egory:	NC	R: Yes 1	No DQA	۱:	Date:			
				Disposition: QA: N/C Closed: _								
NCR:		V	VORK ORI	DER NON-CONFO	RMANCE	(NCR		. ,				
DATE	STEP	Description of NC	Corrective Action Section B			Verification   Anne			Approval	Approval		
DAIL	Section A		Initial Chief Eng	Action Descript Chief Eng	tion	Sign & Date	Section C		Chief Eng	QC Inspector		
								,				
			!									
·												
			,									
								4				
			1 1			1				1		

NOTE: Date & initial all entries

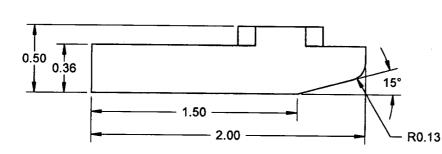




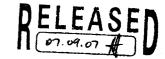
SHOP COPY
RETURN TO
RETURN TO
ENGINEERING
UNCONTROL LEDY COLUMN
SUBJECT TO AMERICANE
WITHOUT NOTICE.

WORK ORDISK

BS10-5-19



# D3657-1 GUIDE TOOL (WAS GENEVA P/N G12170)



WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

NOTES:

1) MATERIAL: 6061-T6 (OR T651/-T6510/-T6511/-T62) ALUMINUM BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116/4160)

- (REF DART SPEC M6061T6B)
  2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3657-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.04 lbs

☐ A	NEWIS	SUE; REPLAC	EC C12170	1			
	MEAAIO	SUE, REFLAC	ES G12170	LE	07.07.27		
REV.			BY	DATE			
DESIG	N	ÇLB	DART AEROSPA	CE USA	ISA. INC.		
DRAW	N	LE		PORT HADLOCK, WA			
CHECK	CHECKED B		DRAWING NO.		REV. A		
MFG. A	PPR.	臣	D3657		SHEET 1 OF 1		
APPROVED 10		10	TITLE	SCAL			
DE APPR.			GUIDE TOOL		3:2		
DATE	07.0	7 27	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS				

Dart	<b>Aeros</b>	pace	Ltd
------	--------------	------	-----

W/O:		WORK ORDER CHANGES										
DATE	STEP	PRO	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
			•	1								
			•		,							
Part No	:	PAR #:	Fault Categ	jory:	NCI	R: Yes	No <b>DQ</b>	A:	Date: _			
_			Disposition: (									
NCR:			WORK ORDE	R NON-CONFORM	MANCE	(NCR	)					
DATE	STEP	Description of NC		Corrective Action Section B			Verific	cation	Approval	Approval		
	JILI	Section A	Initial Chief Eng	Action Description Chief Eng	<b>n</b>	Sign & Date		on C	Chief Eng	QC Inspector		
,			;									
-			,									
					•							
	<b>\</b>			!								
	+	1										
				•								

NOTE: Date & initial all entries